

**\*77111\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 25/11/2011      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 09/12/2011      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop \*NR2\*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3204	Rev A1

0.00

**\*100\***

BAND SAW . . .

Bandsaw

## Memo

0.00

## Jeaspa Bandsaw

Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)

110

0.00

**\*110\***

## HAAS CNC VERTICAL MACHINING #1

HAAS 1

## Memo

0.00

## HAAS CNC vertical machine #1

1- Machine as per Folio FA344 and Dwg D32042- DeburIdentify as D3204-3

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77111

**\*77111\***

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November-25-11 1:38:25 PM

Item ID: D3204-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Arm  
 Start Date: 25/11/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 09/12/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		B.A 11/12/28		4	0		
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>WA04</u>  Memo	0.00  0.00							11/12/28 SP/4
150 <b>*150*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							CK 12/01/02

11/12-29  
4

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**NOTE:** Date & initial all entries

# Picklist Print

November-25-11 1:38:29 PM

Page 1

Work Order ID: 77111

\*77111\*

Parent Item: D3204-3

\*D3204-3\*

Parent Item Name: Arm

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.00 0		Purchased	No			100	f	16.1683	0.5538	2.331789			

\*M6061T6B0 500X02 000\*

\*\*

6061-T6 Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT002

16.1683

114488

16.1683

2.332 *sub 11/12/21*

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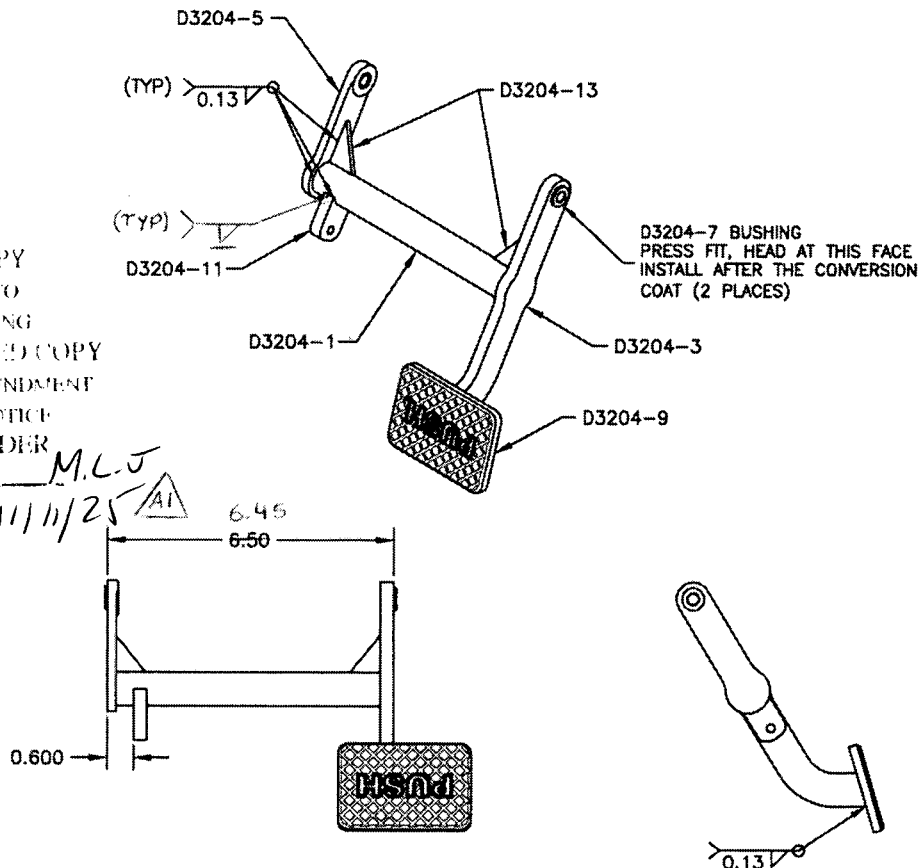




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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

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04.04.30

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SUBJECT TO AMENDMENT  
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WORK ORDER  
NO. 77111 M.C.J.



### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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**Dart Aerospace Ltd**

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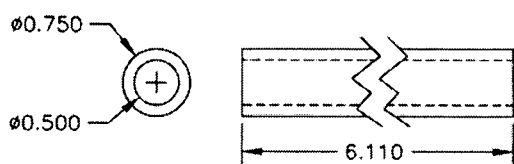
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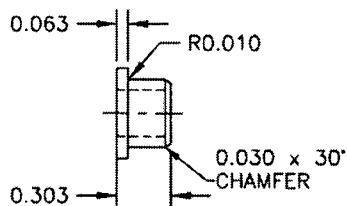


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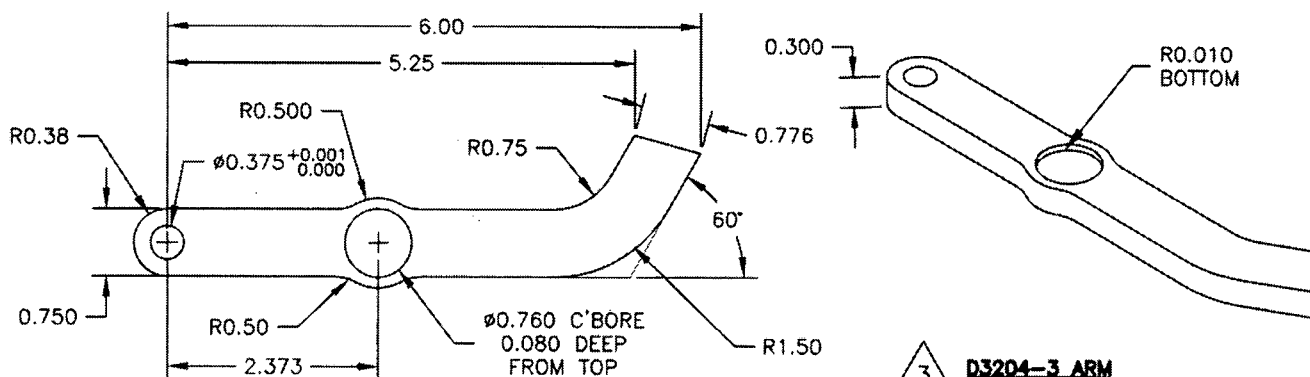
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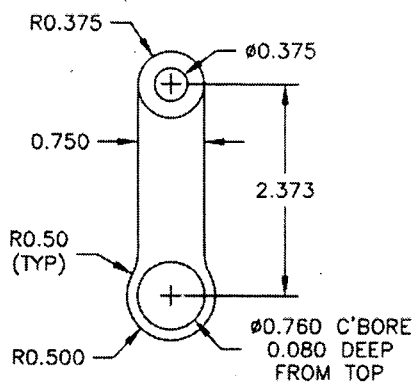
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SCALE 1:2



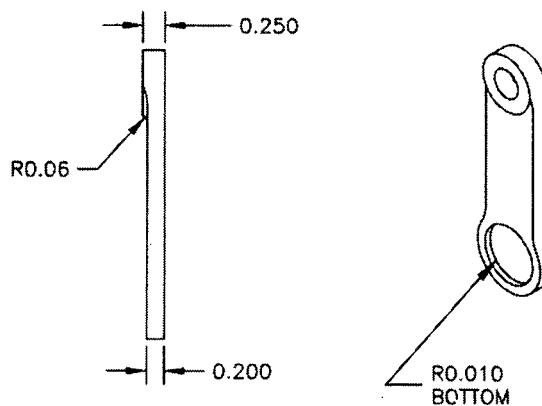
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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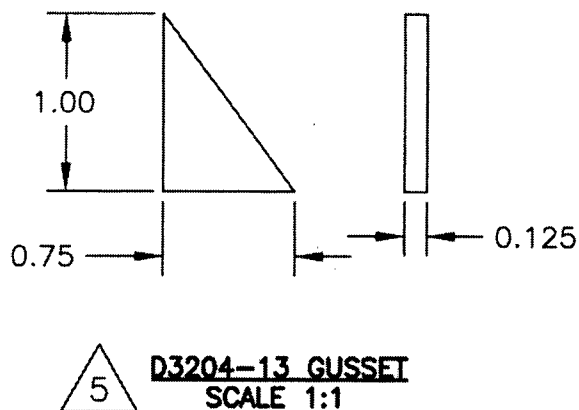
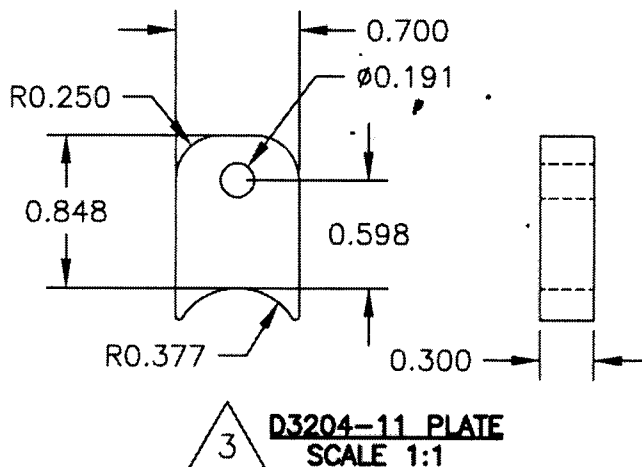
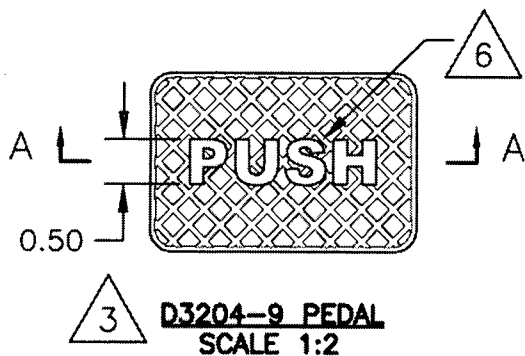
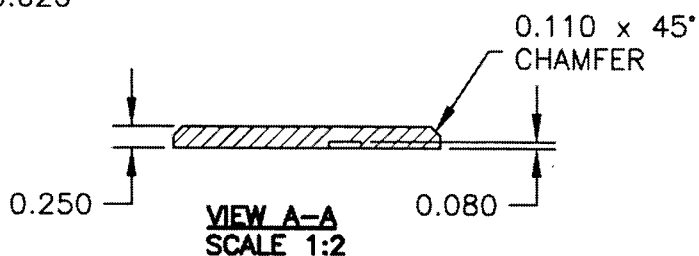
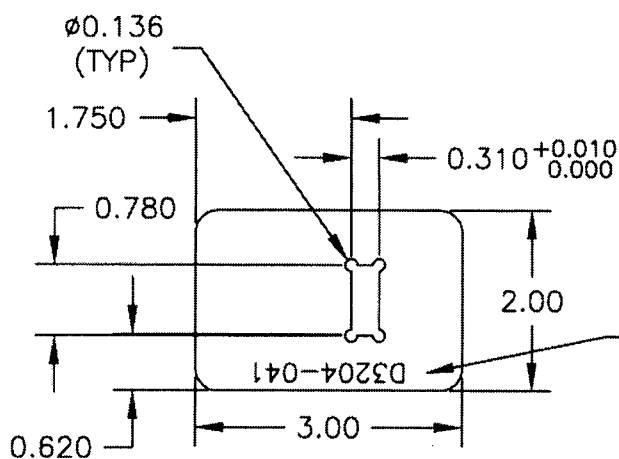
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